



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

D3201-1
Job Sheet 170132



⑦

Part No: D3201-1

Job Qty: 10 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/10/18

Job Tracking No:

Due Date: 1/19/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A Removed from 9 Digit 06-01-25 JLM IPP Rev:B Now on Waterjet 06-08-14 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	1/18/18	1/18/18	0.00	0.00	Start Up Waterjet		Sc 18/01/11
100	Waterjet	10 pcs	1/18/18	1/18/18	0.00	0.38	Waterjet1		Sc 18/01/11
120	QC	10 pcs	1/18/18	1/18/18	0.00	0.00	QC8		Sc 18/01/11
130	Small Fab	10 pcs	1/18/18	1/18/18	0.00	0.25	Small Fab 3		2018/01/17
140	HandFinish	10 pcs	1/19/18	1/19/18	0.00	0.37	HandFinish1		AT 18-1-18
150	QC	10 pcs	1/19/18	1/19/18	0.00	0.00	QC7-2		AT 18/01/18
160	Packaging	10 pcs	1/19/18	1/19/18	0.00	0.00	Packaging3		
170	QC21-SA	10 Ea	1/19/18	1/19/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D3201

Descriptions: 130 - Deburr Stack

DAS
21
3-89

JAN 19 2016

Job Allocations

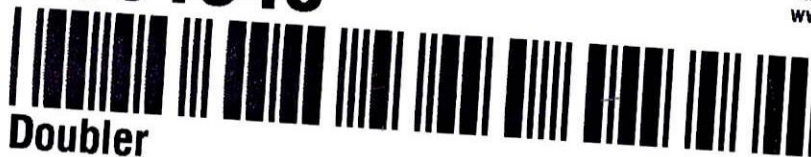
Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.040	3	61	0	0

M138389
3.456

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.500inches ± 0.030	0.530 0.470	0,500	
2	Doubler	3.570inches ± 0.030	3.600 3.540	3,571	
3	Doubler	0.120inches ± 0.030	0.150 0.090	0,120	
4	Doubler	8.000inches ± 0.030	8.030 7.970	8,005	
5	Doubler	0.580inches ± 0.030	0.610 0.550	0,586	
6	Doubler	4.890inches ± 0.030	4.920 4.860	4,889	
7	Doubler	0.250inches ± 0.030	0.280 0.220	0,256	
8	Doubler	0.040inches ± 0.010	0.050 0.030	0,040	

DART
AEROSPACE
S031548



Doubler

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PART NO:
Revision:
Operation:
Change No:

D3201 - 1

Start up Operation

Mfg Date: 01/11/18
Job No: 170132



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Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D3201-1 Revision: Doubler														
170	QC21-SA	S031548	170132	10 Ea	0	S031548	ST023	Box	Stock	1/11/2018	Issue Container			
Operation Totals:		1		10	0									
Part Totals:		1		10	0									
Part Number: M2024T3S.040 Revision: 2024-T3 .040 Sheet														
100	Receive sf	S031547	170132	1 sf	0		Start Up Waterjet		Stock	1/11/2018	Issue Container			
Operation Totals:		1		1	0									
Part Totals:		1		1	0									
Totals:		2		11	0									

Plex 1/19/2018 9:04 AM Dart.Lajeunesse.Marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					